

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015409**Date Inspected:** 04-Jul-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wuzhi Cheng**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, M.Manikandan was present during the time noted above for observations relative to the work being performed.

**OBG # TRIAL ASSEMBLY YARD**

This QA inspector performed dimensional joint survey along with ABF and ZPMC for U-Rib to confirm offset for below segment. The measurements are recorded in the designated sheet and forwarded to team leader for further action.

9BE-9CE

**OBG # TRIAL ASSEMBLY YARD**

This QA inspector performed dimensional joint survey along with ABF for Suspended bracket using socket template. The measurements are recorded in the designated sheet and forwarded to team leader for further action. The Suspended brackets designations reviewed are as follows:

SB50E

SB52E

SB52W

SB56E

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SB56W

SB58E

SB60W

SB62E

SB64E

SB68E

SB70E

For additional information please reference the pictures below:

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD (9AW-9BW)

SMAW Process:

Welding of weld joint – 045 located on PCMK SEG051A, longitudinal weld joins bottom panel to side panel at 9AW and 9BW. Welder is identified as 068097. ZPMC CWI is identified as Li Yang. Welding was been performed against welding repair report B-CWR1695. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-1G (1F)-FCM-Repair-1.

OBG # TRIAL ASSEMBLY YARD (9AW-9BW)

SMAW Process:

Welding of weld joint – 012 located on PCMK SEG049A, longitudinal weld joins bottom panel to side panel at 9AW and 9BW. Welder is identified as 045221. ZPMC CWI is identified as Li Yang. Welding was been performed against critical welding repair report B-CWR1695. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-1G (1F)-FCM-Repair-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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### Summary of Conversations:

No relevant conversation.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Manikandan,Murugan
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Quality Assurance Inspector
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<b>Reviewed By:</b>	Carreon,Albert
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QA Reviewer
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